

P804228/WO/1

DaimlerChrysler AG

Abstract

The invention relates to a method and a device (1) for producing a peripherally closed hollow profile (3) having a secondary feature and/or a branch (4), said hollow profile (3) being shaped from a hollow profile blank by means of internal high pressure. Accordingly, the cap (11) of the secondary feature and/or of the branch (4) is severed by means of a counterholding punch (5, 17) supporting the secondary feature or the branch (4) during the shaping process. In order to permit the production of a hollow profile (3) having secondary features and/or branches (4), during which the cap (11) of the secondary feature or of the branch (4) is severed in a simple and reliable manner in terms of the process, it is proposed that the cap (11) of the secondary feature and/or of the branch (4) be severed at an internal high pressure which corresponds at most to the forming pressure for forming the hollow profile (3) from the blank, the severing being effected solely by a stroke of the counterholding punch (5, 17) in the opposite direction to the expansion direction of the hollow profile (3). The end face (8) of the counterholding punch (5, 17) runs in a continuously even manner, the end edge (12, 21) of the punch (5, 17) forming the severing contour. The width of the annular gap (22) between the wall (14) of the passage (7), which is formed in the forming tool (2) and in which the punch (5, 17) is guided in a displaceable manner, and the punch circumference (13) corresponds approximately to the wall thickness of the secondary feature or of the branch (4).

(according to figure 2)